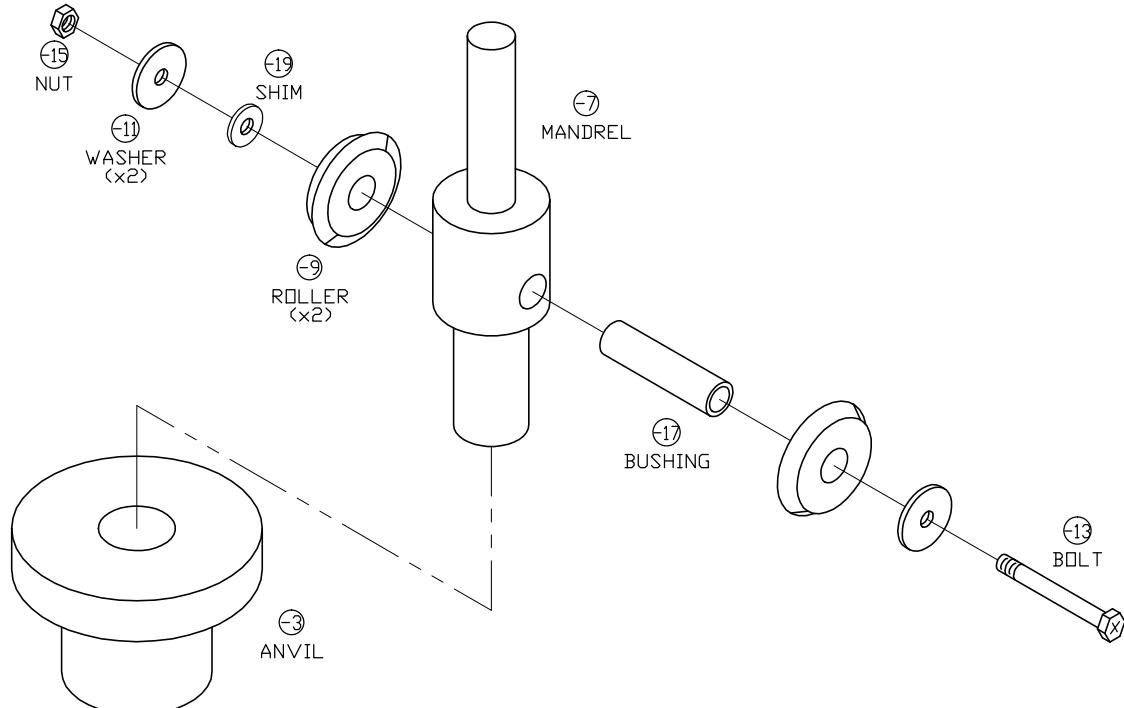


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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED
1	CH'D -11 FROM WASHER - AN970-3.	8/11/16	WP
2	CH'D -11 HOLE DIA. TO .188, CH'D DWG. NO. TO RB T101584, DELETED -5 NON-ASSOCIATIVE FROM BOM, CH'D -17 & -19 INFO ON BOM.	5/12/09	RJC
3	ADDED -5 ASSEMBLY PER E.B. CH'D -17 OVERALL LENGTH FROM 1.680 +.007-.000 & RC 48-52 PER D.W. ADDED -21, ADDED NOTE 1 FOR -19 & -21 PER R.W.	9/23/11	RJC



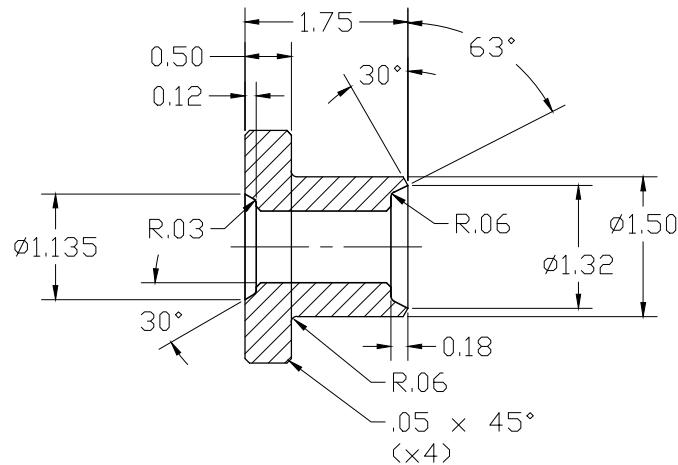
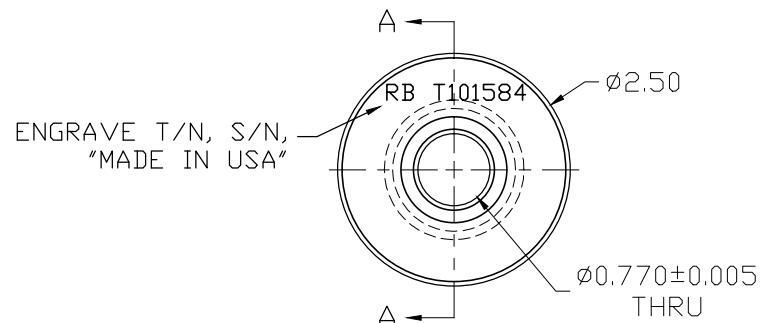
ASSY QTY	ASSY QTY	B/D	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/D INFORMATION OR SPECIFICATIONS	Pg.
		-3	1		ANVIL	4140	$\phi 2\text{-}1/2 \times 1\text{-}7/8$	2
X		-5	1		ROLL STAKING TOOL ASSY.			3
1		-7			MANDREL	4140	$\phi 1\text{-}1/4 \times 4\text{-}7/8$	4
2		-9			ROLLER	DHTS	$\phi 1\text{-}1/2 \times 3/4$	5
2		-11			WASHER	4140 Q&T	$\phi 3/4 \times 3/16$	6
1	B/D	-13			BOLT	STEEL	#AN3-20A	1
1	B/D	-15			NUT	STEEL	#MS21042	1
1		-17			BUSHING	01	$\phi 7/16 \times 1\text{-}3/4$	7
A/R	B/D	-19			SHIM	STEEL	$\phi .344 \text{ O.D.} \times \phi .187 \text{ I.D.} \times .0025$ MCMASTER-CARR #99040A002	8
A/R	B/D	-21			SHIM	STEEL	$\phi .308 \text{ O.D.} \times \phi .210 \text{ I.D.} \times .0020$ MCMASTER-CARR #Z9883-20	9
ASSY		5						

RB RED BARN MACHINE

TITLE	
ROLL STAKING TOOL	
DWG NO.	REV
RB T101584	3
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
TOLERANCES ON: METRIC REF.	
.XXX ± .005	.Xmm ± .1mm
.XX ± .01	FRACTIONS ± 1/32
.X ± .1	ANGLES ± 5°
DRAWN BY: COLE	
APPROVED <i>D. West</i>	
HEAT TREAT FINISH	
SPEC	
USED ON MODEL	
BELL 206, TH-57A	
SCALE	NTS
DATE	10-6-00
SHEET	1 of 9

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REV		DESCRIPTION		DATE	INITIAL	APPROVED

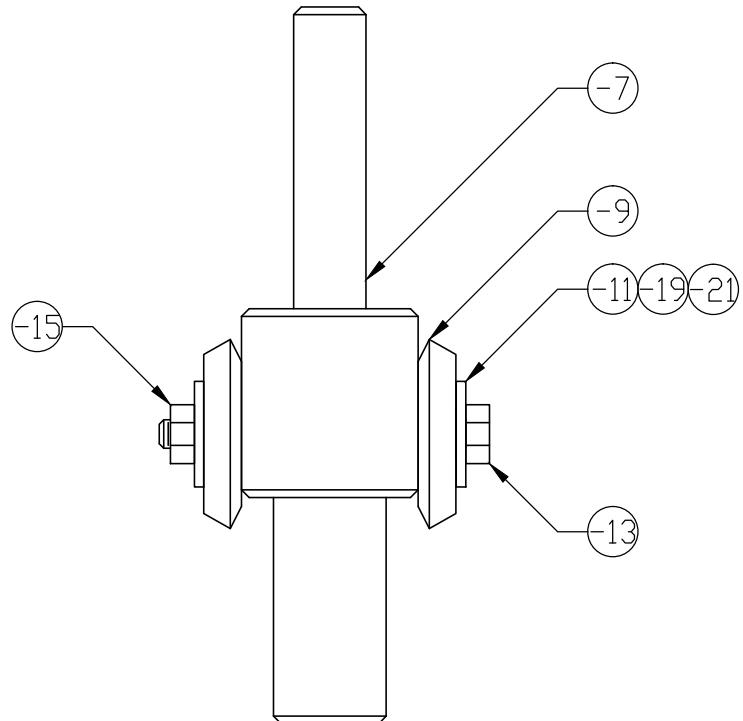


(3)
ANVIL

 RED BARN MACHINE	
TITLE ROLL STAKING TOOL	
DWG NO.	REV 3
UNLESS OTHERWISE SPECIFIED DRAWN BY: COLE	
DIMENSIONS ARE IN INCHES APPROVED <i>D. Weil</i>	
TOLERANCES ON: METRIC REF.	
DECIMALS .XXX ± .005 .XXmm ± 1mm	
.XX ± .01 FRACTIONS ± 1/32	
.X ± .1 ANGLES ± .5°	
SPEC QQ-P-416F, TYPE II, CLASS II	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES USED ON MODEL	
.015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING BELL 206, TH-57A	
SCALE NTS	DATE 10-6-00 SHEET 2 of 9

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REV		DESCRIPTION		DATE	INITIAL	APPROVED
3		ADDED -5 ASSEMBLY PER E.B.		9/23/11	RJC	

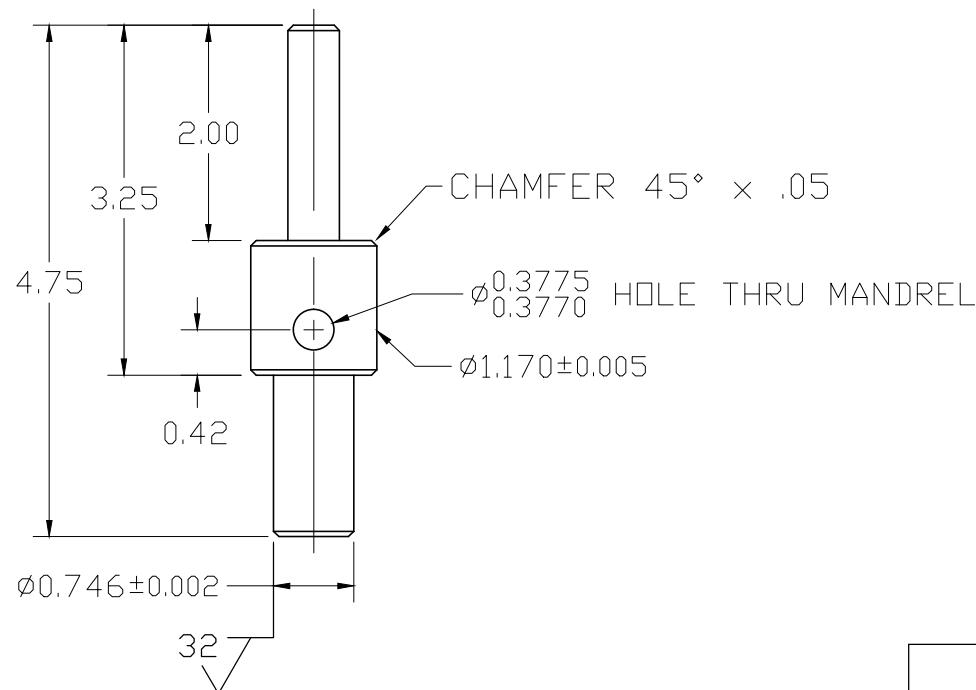
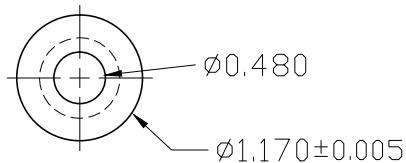


(-5)
ROLL STAKING TOOL
ASSEMBLY

RED BARN MACHINE	
TITLE	
ROLL STAKING TOOL	
DWG NO.	RB T101584-5
REV	3
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS	METRIC REF.
.XXX ± .005	.Xmm ± 1mm
.XX ± .01	FRACTIONS ± 1/32
.X ± .1	ANGLES ± .5°
DRAWN BY: COLE	
APPROVED	<i>D. Weil</i>
HEAT	
TREAT	
FINISH	
SPEC	
USED ON MODEL	
BELL 206, TH-57A	
SCALE	NTS
DATE	10-6-00
SHEET	3 of 9

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REV		DESCRIPTION		DATE	INITIAL	APPROVED



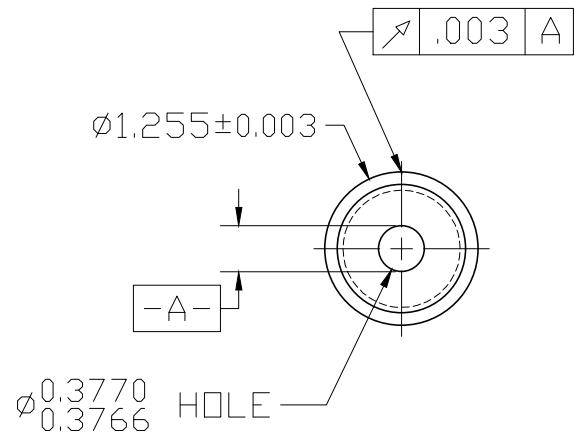
(-7)

MANDREL

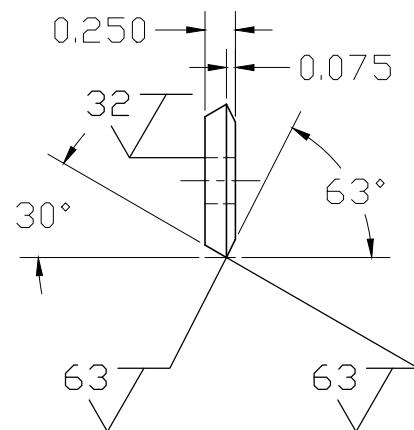
RED BARN MACHINE	
TITLE ROLL STAKING TOOL	
DWG NO.	REV 3
RB T101584-7	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS METRIC REF. .XXX ± .005 .XXmm ± 1mm	
.XX ± .01 FRACTIONS ± 1/32	
.X ± .1 ANGLES ± .5°	
SPEC QQ-P-416F, TYPE II, CLASS II	
1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 10-6-00
SHEET 4 of 9	

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REV		DESCRIPTION		DATE	INITIAL	APPROVED



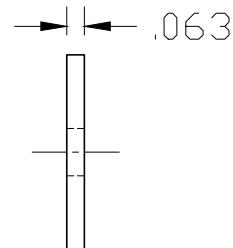
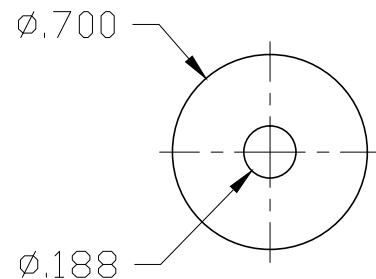
(-9)
ROLLER



RB RED BARN MACHINE	
ROLL STAKING TOOL	
DWG NO.	REV
RB T101584-9	3
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS METRIC REF.	
.XXX ± .005 .Xmm ± 1mm	
.XX ± .01 FRACTIONS ± 1/32	
.X ± .1 ANGLES ± .5°	
DRAWN BY: COLE	
APPROVED <i>D. Weil</i>	
HEAT TREAT RC 55-60	
FINISH BLACK OXIDE	
SPEC	
USED ON MODEL	
BELL 206, TH-57A	
SCALE NTS	DATE 10-6-00
SHEET 5 of 9	

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
2	CH'D -11 HOLE DIA. TO .188.	5/12/09	RJC



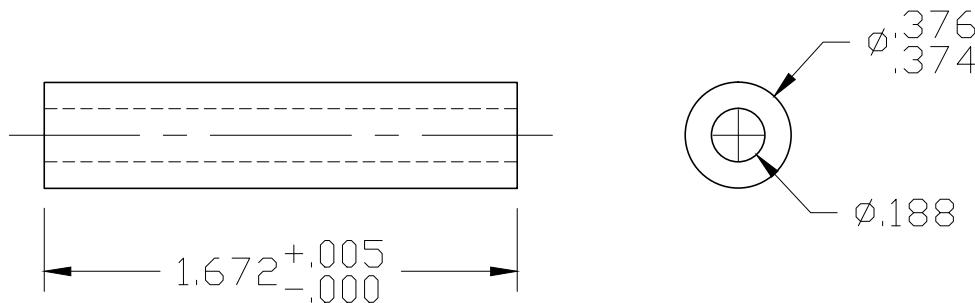
(-11)

WASHER

RB RED BARN MACHINE	
ROLL STAKING TOOL	
DWG NO.	RB T101584-11
UNLESS OTHERWISE SPECIFIED	DRAWN BY: COLE
DIMENSIONS ARE IN INCHES	APPROVED <i>D. Weil</i>
TOLERANCES ON: METRIC REF.	
DECIMALS .XXX ± .005	.Xmm ± 1mm
.XX ± .01	FRACTIONS ± 1/32
.X ± .1	ANGLES ± .5°
SPEC QQ-P-416F, TYPE II, CLASS II	
1. BREAK ALL SHARP EDGES	
.015 x 45° PR .015 R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE	NTS
DATE	10-6-00
SHEET	6 of 9

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REV		DESCRIPTION		DATE	INITIAL	APPROVED
3		CH'D -17 OVERALL LENGTH FROM 1.680 +.007-.000 & RC 48-52 PER D.W.		9/23/11	RJC	



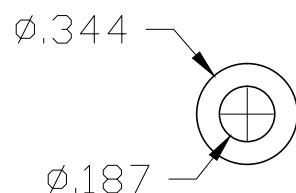
(-17)

BUSHING

RB RED BARN MACHINE	
ROLL STAKING TOOL	
DWG NO.	RB T101584-17
REV	3
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS METRIC REF.	
.XXX \pm .005	.XXmm \pm 1mm
.XX \pm .01	FRACTIONS \pm 1/32
.X \pm .1	ANGLES \pm 5°
SPEC	
DRAWN BY: COLE	
APPROVED <i>D. Weil</i>	
HEAT	RC 48-52
TREAT	
FINISH	BLACK OXIDE
USED ON MODEL	
BELL 206, TH-57A	
SCALE	NTS
DATE	10-6-00
SHEET	7 of 9

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REV		DESCRIPTION		DATE	INITIAL	APPROVED
3		ADDED NOTE 1 PER R.W.		9/23/11	RJC	



.0025±.0005

-19

SHIM

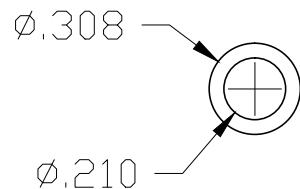
NOTES

- FOR REFERENCE ONLY, B/D SHIM SPECS.

RB RED BARN MACHINE	
TITLE ROLL STAKING TOOL	
DWG NO.	RB T101584-19
REV	3
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
TOLERANCES ON: METRIC REF.	
DECIMALS .XXX ± .005 .Xmm ± 1mm	
.XX ± .01 FRACTIONS ± 1/32	
.X ± .1 ANGLES ± .5°	
SPEC	
USED ON MODEL	
HEAT TREAT FINISH	
BELL 206, TH-57A	
SCALE	NTS
DATE	10-6-00
SHEET	8 of 9

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REV		DESCRIPTION		DATE	INITIAL	APPROVED
3		ADDED -21, ADDED NOTE 1 PER R.W.		9/23/11	RJC	



.0020±.0005

-21

SHIM

NOTES

1. FOR REFERENCE ONLY, B/D SHIM SPECS.

 RED BARN MACHINE	
TITLE ROLL STAKING TOOL	
DWG NO.	RB T101584-21
REV	3
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS METRIC REF.	
.XXX ± .005 .Xmm ± 1mm	
.XX ± .01 FRACTIONS ± 1/32	
.X ± .1 ANGLES ± .5°	
SPEC	
USED ON MODEL	
BELL 206, TH-57A	
SCALE	NTS
DATE	10-6-00
SHEET	9 of 9